

Work Order ID 77013 - 2

77013

Page 1

Thursday, November 24, 2011 3:21:10 PM

Item ID: D4155-1

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bar

Start Date: 11/24/2011 Start Qty: 8.00

8

Cust Item ID:

Required Date: 12/5/2011 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan:

Date: 11-24

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4155

B

100

0.00

100

Cold Saw

Memo

0.00

Hyd Mech

Cut blanks at 91.75"

110

0.00

110

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Mill as per folio FB048 & dwg D4155,
FOLIO REV: _____
DWG REV: _____

2-Deburr as required

Manual Mill

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77013

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Page 2

Thursday, November 24, 2011 3:21:10 PM

Item ID: D4155-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bar
Start Date: 11/24/2011 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 12/5/2011 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00							
Quality Control									
140		0.00							
140									
Small Fab	Memo	0.00							
Small Fab	Grind off chamfer on fwd end of bar as per dwg								

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 77013***77013***

Page 3

Thursday, November 24, 2011 3:21:10 PM

Item ID: D4155-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bar

Start Date: 11/24/2011 Start Qty: 8.00

8

Cust Item ID:

Required Date: 12/5/2011 Req'd Qty: 8.00

8

Customer:

Reference:

Run Start ***NR1***

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	Memo	0.00							
Quality Control									
160	Identify as per dwg & Stock Location: <i>W/A</i>	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

*(x6)**EL 11-12-21 (x6)**11/12/22 [Signature]
MKF 11-12-21*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Page 1

Thursday, November 24, 2011 3:21:14 PM

Work Order ID: 77013

77013

Parent Item: D4155-1

D4155-1

Parent Item Name: Bar

Start Date: 11/24/2011

Required Date: 12/5/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A 10.08.03 new issue DD verf:EC
11.04.14 as per dwg revB DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304B0.250x0.500

Purchased

No

100

f

1,035.416

7.6333

64.28042

M304B0 250x0 500

**

304 BAR .250 x .500

Location

Loc Qty

Loc Code

MAT006

997.522

117842

8.3

119050

21.67

119159

967.552

MAT050

37.8947

117176

37.8947

66 ~~8~~ 11/12/14

M304 B 0.25 x .500

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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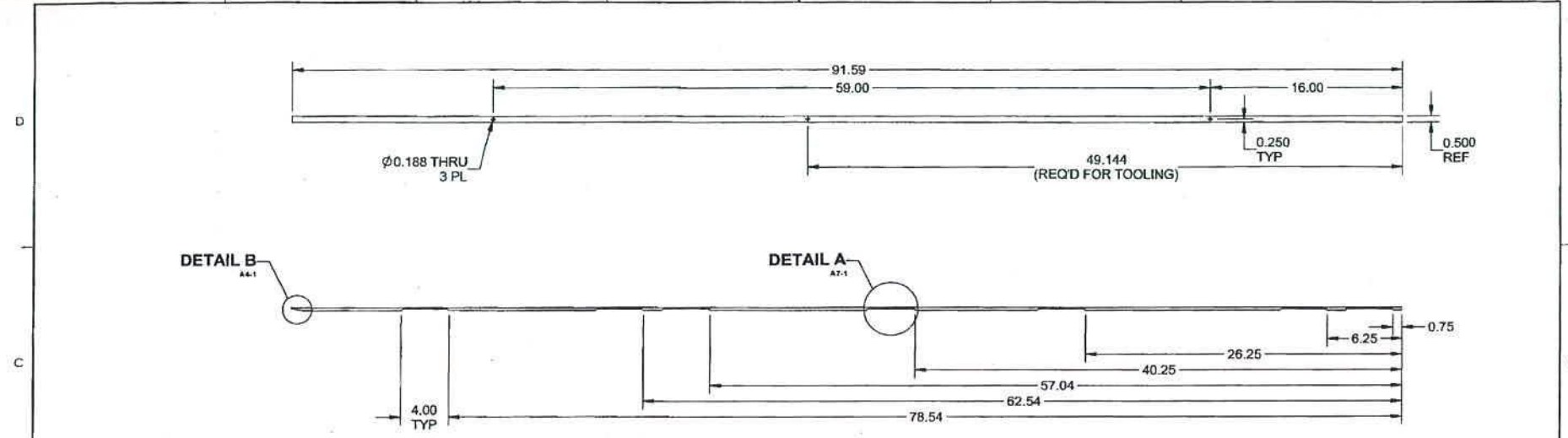
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

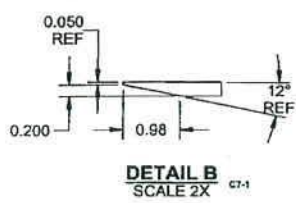
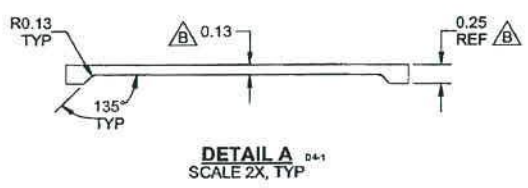
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D4155-1 BAR



SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 77013
 11/11-21

RELEASED
 2011-04-13

- NOTES:**
- 1) MATERIAL : AISI 304/316 STAINLESS STEEL BAR, 0.25 THICK X 0.50 WIDE PER ASTM A276 OR ASTM A240 REF. DART SPEC. M304B0.250X00.500
 - 2) FINISH : NONE
 - 3) TOLERANCES : PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS : INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES : 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION : NONE
 - 7) WEIGHT : 2.82 lbs

B	CHANGED MANUFACTURING PROCESS; MATERIAL WAS 0.50 THICK (A6-1); 0.25 REF WAS 0.20 (B6-1); 0.13 WAS 0.08 (B7-1)	MB	11.04.05
A	NEW ISSUE	SC	10.07.22
REV.	DESCRIPTION	BY	DATE
DESIGN	SC		
DRAWN	SC		
CHECKED	JP		
MFG. APPR.			
APPROVED	MP		
DE APPR.	MP		
DATE	11.04.05		

DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWING NO. D4155	REV. B SHEET 1 OF 1
TITLE BAR	SCALE NTS

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